

Work Order ID 55310 - 1

January 13, 2010 10:19:28 AM

Page 1

SPKIP



Item ID: D2230-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 1/13/10 Start Qty: 200.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

PL

Date: 10-1-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev F

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 extrusion to 0.82"

Batch:

0.00

0.00

cut 24 Notes W

110



HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio D2230-3
Check for crack while loading into the machine.
2- deburr

0.00

0.00

PO11124

Pl 10-1-14
200
Leighs 50

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

Receiver Inspect.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect parts - second check

0.00

⇒ S. Dorlos

counted
x50



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ U 10/02/08

X50



HandFinish

Memo

0.00

Hand Finishing

160

QC3- Inspect Part Finish

0.00

BK 10 02 9

50



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES						
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Setup Start



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Item Name: Lug

Start Date: 1/13/10 Start Qty: 200.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME: 8:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:30AM

0.00

=> 41 10/02/09

50

φ

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

PK 10-02-9

50 φ

190



Packaging

Packaging

Identify as per dwg & Stock Location: 476

0.00

Memo

0.00

Ref 4/11 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Setup Start



Revision ID:

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Item Name: Lug

Start Date: 1/13/10

Start Qty: 200.00



Cust Item ID:

Required Date: 1/20/10

Req'd Qty: 200.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11 *[Signature]*
me
10-2-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

January 13, 2010 10:19:31 AM

Page 1

Work Order ID: 55310



Parent Item: D2230-3



Parent Item Name: Lug

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP ☐ D ☐ 00.05.18 ☐ Added inspection level 8, and removed P/O for powder coat ☐ EC ☐

Start Qty: 200.00

Required Qty: 200.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	604.4578	14.3789			



Lug Extrusion

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	604.4578379	
43722	175.629406	
44529	5.7731	
45800	423.055332	



u 10.27-13
sant fouldbec

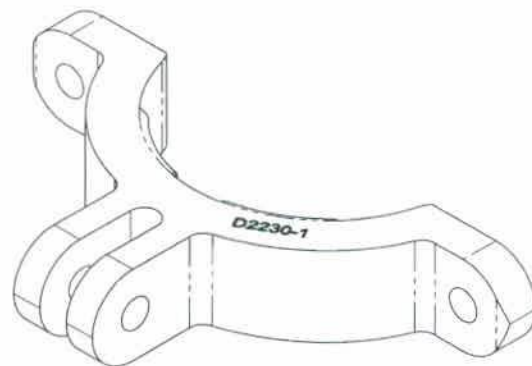
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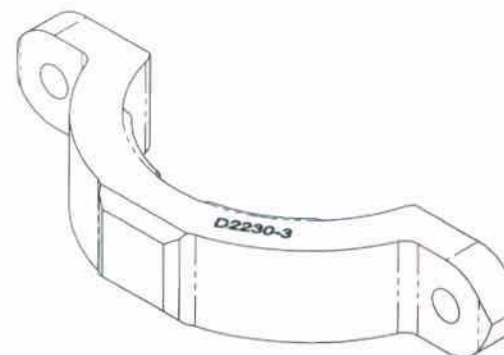
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D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 55310
PRC-1-13

RELEASED
01/01/16

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION	AJS	09.01.16
F	REDESIGN, R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	04.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

W/O:		WORK ORDER CHANGES						
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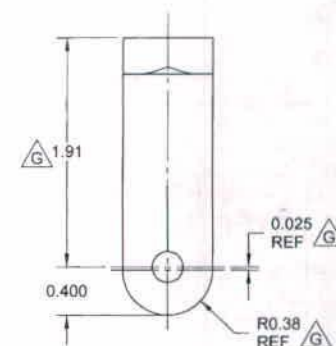
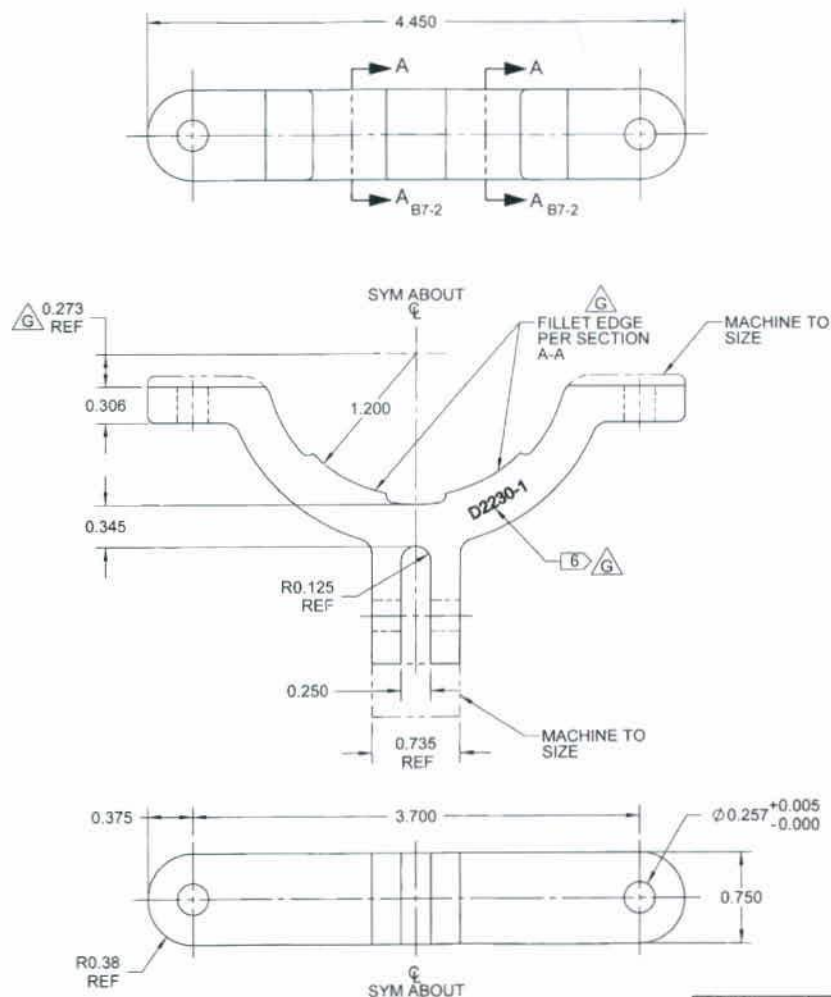
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NOTE: Date & initial all entries

SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

RELEASED
09/06/25/16

W10 55310

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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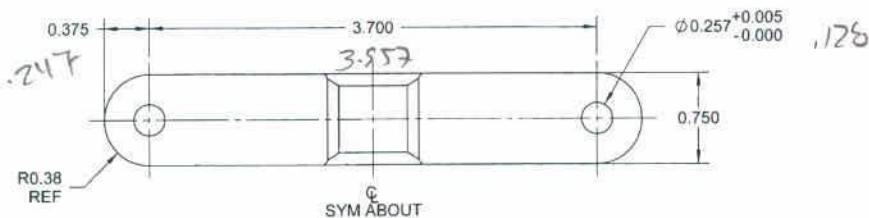
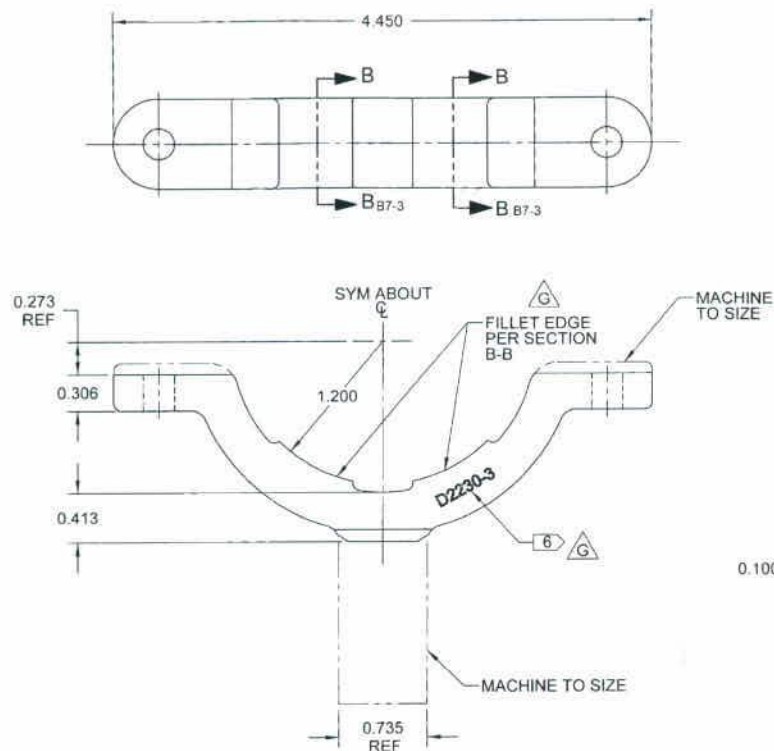
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NOTE: Date & initial all entries

SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/23

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO11126

Purchase Order Date 1/14/10

PO Print Date 1/14/10

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

FAKED
SAV 14

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2230-3P	LUG	1/18/10 Yes	200.00 Each	Yours ppd	\$10.4000	\$2,080.00
		Special Inst:	MACHINE AS PER DWG D2230 REV.F MAT. SUPPLY BY DART D2423 B45800				
2	D3235-1P	lug	1/18/10 Yes	60.00 Each	Yours ppd	\$13.9000	\$834.00
		Special Inst:	MACHINE AS PER DWG; D3235 REV. A MATERIAL SUPPLY BY DART D2423 B45800				
PO Total:							\$2,914.00

Change Nbr: 1

Change Date: 1/14/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17214
Date: Feb 05, 2010
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 11126	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug Material supplied by DART D2423 B45800	Each	200	50	150
D3235-1 Mounting Lug Material supplied by DART D2423 B45800	Each	60		60
Received by _____		Thank you for your order!		

CERTIFICATE OF CONFORMITY

SOLD TO

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

50

D2230-3

Mounting Lug

11126

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

8/10/02/08

Vankleek Hill, February 5, 2010